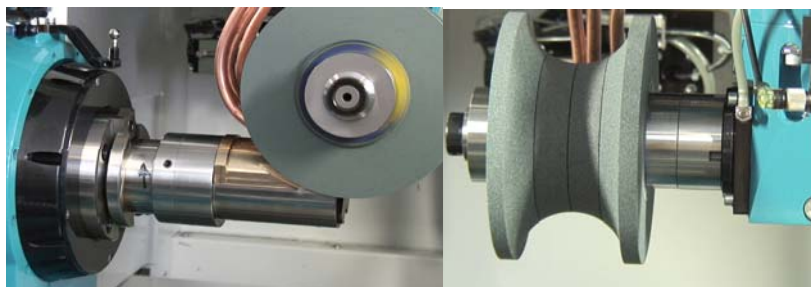





Tool working Pipe

A20-200

The tool is produced by a solid cylinder with conventional wheels. It allows to change the spline geometry fast and economically by simply changing the wheel-DXF and redress the new geometry on the same wheel, and for small splines the wheel can be kept sharp as being redressed when needed.



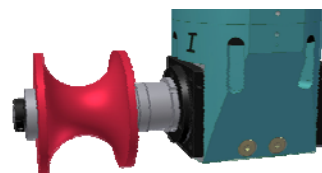
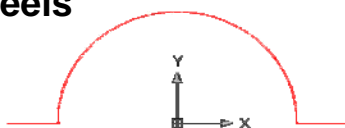
1. Cycletime for Production

Tool specifications			
Diameter 139 mm, Z26, Length of cutting edge 90mm, depth tooth: 5.3mm, Material 18NiCrMo7-6+HH			
Operations			
Feed [mm/Min]		120	5
Power [kW]		1	1
Cutting feed [m/s]		32	24
Used wheels			
Grinding time [s]		120	1440
Total cycle time	26 Min 00		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

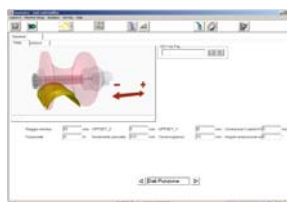
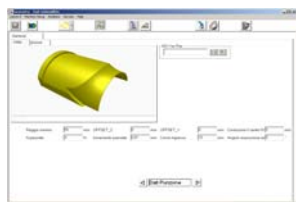
2. Used Grinding Wheels

1 Ø125 DXF Conventional



3. Machine and Software Requirements

1



Machines: 5 axes CNC grinders : NORMA CFG
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 5, DXQ
 Engineer: Diego Albiero, 01.04.2009

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